

Date: Tuesday, 8/28/2007 3:22:43 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 34306	
Estimate Number : 10600	
P.O. Number : N/A	Part Number : D2519
This Issue : 8/28/2007 S.O. No. : N/A	Drawing Number : D2519 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : D
Previous Run : 26216	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 9/21/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 100 Um: Each
Comment : Est: B 00.03.16 Re-format, laser cutting EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 4482

Laser cut as per Dwg D2519

Material release note required

C207108129

(100)

CFI

JTD

2.0	D2519F	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Clamp

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

P275/26

(100)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

(8.561" center to center)

En 7/10/06

(100)

counts

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr any rough edges after tumbling

2-Bend as per Dwg D2519

N/A 8/28/07

JAN 07-10-06

cocited

(100)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/29	1	Permanent change		07/08/29		U	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:22:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 34306

Part Number: D2519

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

count
09/10/11 *(400)*

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble

M/A *09/10/11*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *57457*

07/10/12 *(100)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(100)
09/10/12

Job Completion



09/10/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

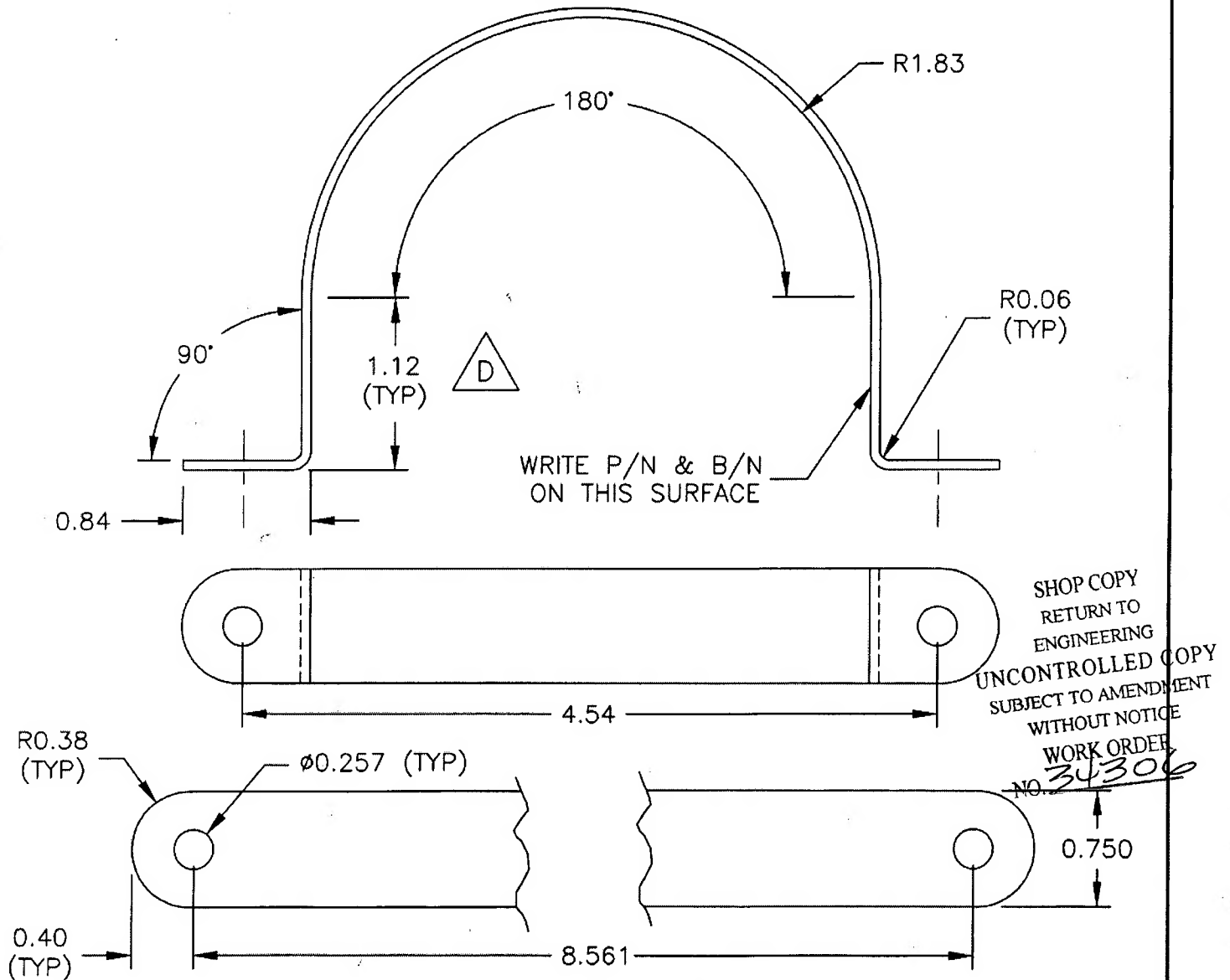
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

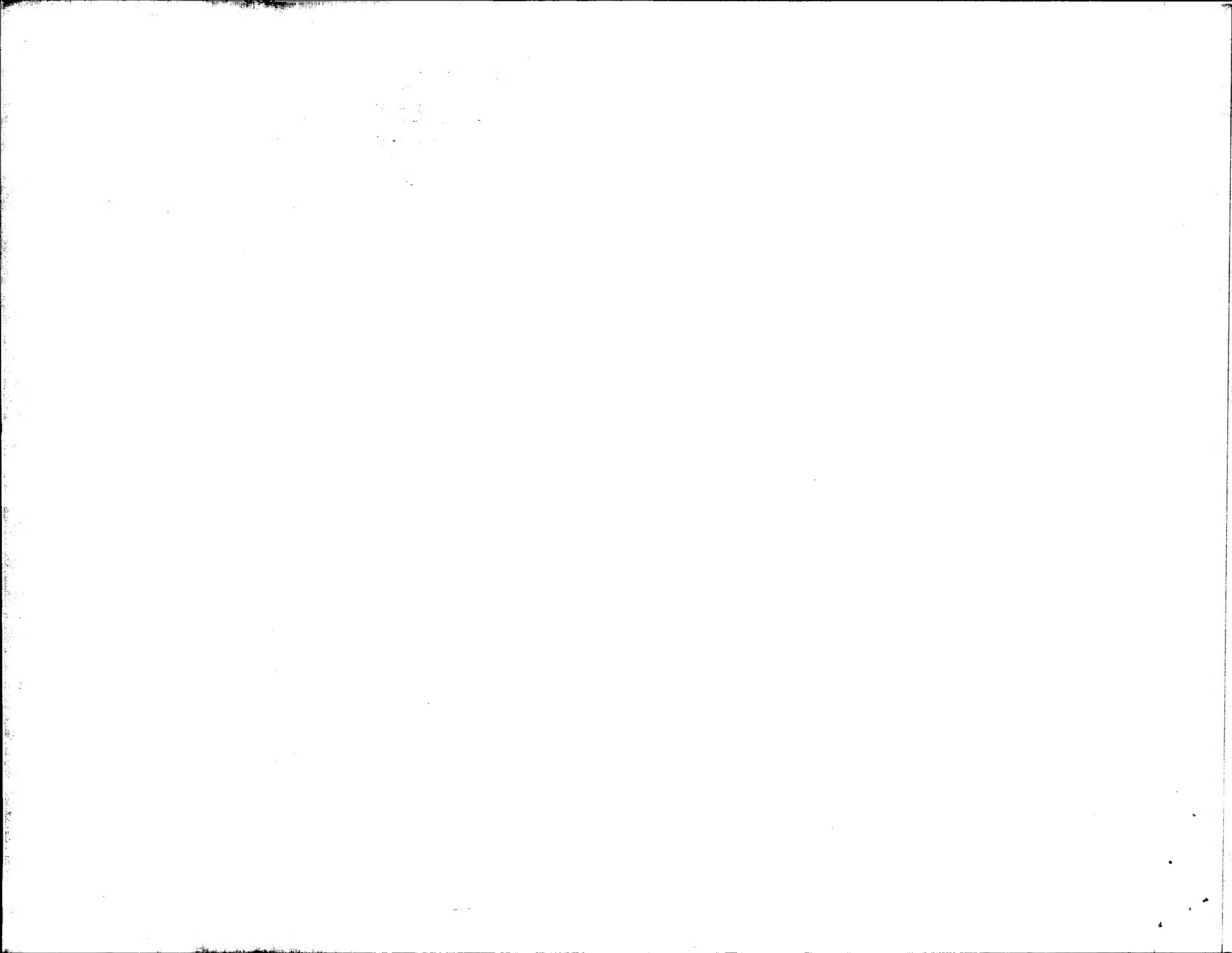
DART

DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2519	REV. D SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

RELEASED
04.11.26**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN

D2519 FLAT PATTERN





180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO
2007/09/24	0374670

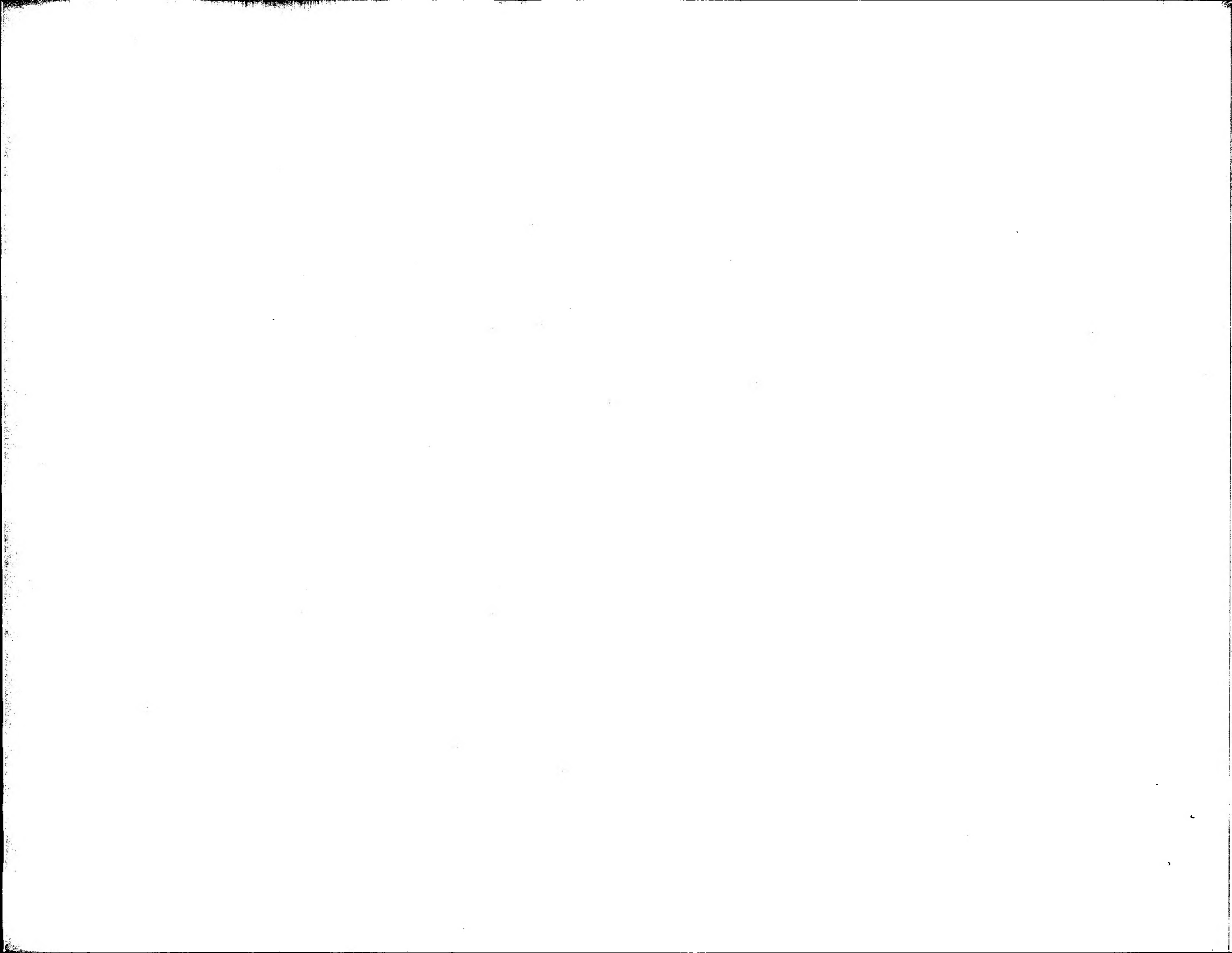
EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

	CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO	VIA SHIP VIA
DART	GFI-0299	J0167590	PO00004482	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO		DESCRIPTION	
100	D2519F		CLAMP	
			CERTIFICATE OF CONFORMANCE REQ	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY



CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	2	OUR JOB NO	J0167590	SHIPPING MEMO	0374670	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	100 PCS	PO00004482	D2519F	D	CLAMP	D
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		SAMUEL / UGINE & ALZ		533008 ATT'D		
PROCESS		PROCESSOR		RELEASE NOTE #		
1						
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **25 SEPTEMBER 2007**

G.F.I. Q.C. REP.

Robert Henry



Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRÉ DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 7 FEVRIER 2006

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 68417
Customer's order #:

de commande SSMQ: 851031
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	10	.062" X 48" X 96"	304 2B		533008

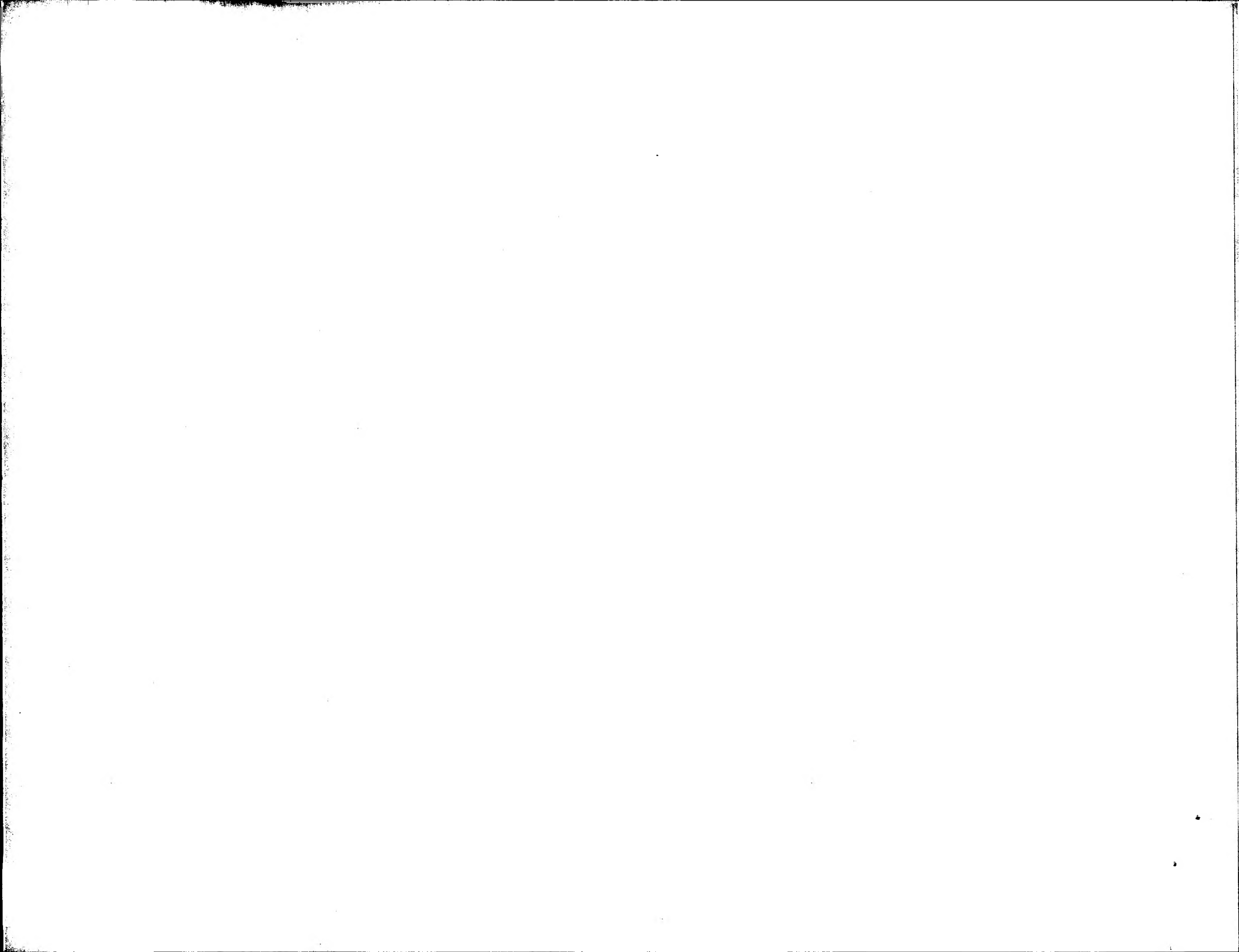
Bien à vous,
Yours truly,

Commis à l'administration.
Adminstratlon Clerk.

LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399
FAX: 514-457-9393

LET. DE. COM 12/01/C





UGINE & ALZ

Groupe Arcelor

UGINE & ALZ France
Immeuble 'La Pacific'
11/13, cours Valmy - La Défense 7
92800 PUTBAUX FRANCE
Tél. +33 1 41 25 60 20 Télécopie +33 1 41 25 60 07

NIP: FR67383719085

PACKING LIST TEST REPORT

Mill Ref : 5UA529275 04
Your REF : SAMUEL C97613 304/304L 2B
Agent's Ref : 48 WIDE COIL
Our REF : 051301035919/82794

SEE ADDRESS OPPOSITE

Sold To:

Ship to:
SAMUEL ET FILS LTEE
2225 FRANCIS HUGUES
H7S1N5 LAVAL CANADA

SAMUEL ET FILS LTEE
2225 FRANCIS HUGUES
H7S1N5 LAVAL CANADA

06102005	Customer	Involved	Agent's No	Country	O/A leadline	File/Load Doc	Dispatch From
151316	60158	60158	572/***	056	Sept 2005	73206/75233	ISBERGUES (BONCOURRE REYNALDE)

By:
Shipping Agent:
TMFOPERATING
Instructions:

DDP3 MTR (Delivered Duty and Taxes includ. M
Forwarding Agent:
OCEAN LOGISTICS

Number of parcels: 2

Mill Ref: 144210
UGINOX 18-9 L COLD ROLLED 2B FINISH
Marks: P.O. C97613 AISI304/304L 2B 0,059" X 48" X COIL

STEEL COILS AISI304L

Edges CL

Item No	Lot No	Packing No	Size/Dimensions	Thickness	Quantity	Net Weight in Kg	Gross Weight in Kg	N
1	63190	L7011	1219,20 48" X 0,059"	1,490 212	1	5560	5593	
1	63190	L7014	1219,20 48" X 0,059"	1,490 212	1	5560	5593	
Total per item 1 (Complete)					2	11120	11186	2
Packing list total					2	11120	11186	2

(Certificate requested)

Mill Ref. / Item	Lot No	Heat No	C %	Si %	Mn %	Ni %	Cr %	Mo %	Ti %	N %	CU %								
144210/1	63190	533008	0,022	0,49	1,49	8,02	18,06			0,060	0,240								S 0,0

Mill Ref. / Item	Lot No	Heat No	(1)	TS PSI	YS PSI 0,2 % 1 %	Elongation 80mm 2"	Hardness	GG	ERICH	Bend										Res Quali
144210/1	63190	533008	T	94105	45530	48 48	85HRB													M. T J

REMINDER Our deliveries are subject only to our general conditions of export sale as listed on the reverse of our order acknowledgement which has been sent to you and stipulating more particularly a clause on the TRANSFER OF PROPERTY

UGINE & ALZ France, s.a. au capital de 355.057.728 EURO - R.C.S. Numéro 382 719 083 Siège social: Immeuble 'La Pacific' 11/13, cours Valmy - La Défense 7 - 92800 PUTBAUX FRANCE